



### DELFLLEET® Evolution

# F3993/95/97

**Conventional Epoxy Primer**  
**Gray/Buff/Black**

F3993/95/97 series are chrome-free, high performance and general-purpose primers, which can be used on a variety of substrates used in the commercial market. These pigmented epoxy primers provide excellent adhesion when applied to properly prepared compatible surfaces listed below, as well as plastic fillers.

#### Products

Conventional Epoxy Primer-(Gray)	F3993
Conventional Epoxy Primer-(Buff)	F3995
Conventional Epoxy Primer-(Black)	F3997
Conventional Epoxy Primer Hardener	F3996
Fast Thinner	F3320
Medium Thinner	F3330
Slow Thinner	F3340
Extra Slow Thinner	F3350
Retarder	F3360

#### Additional Reducer Options\*

Fast Reducer*	F3311
Reducer – Medium*	F3321
Reducer – Slow*	F3331
Reducer – Hot Temperature*	F3341
Retarder*	F3351

*\* Some reducer options contain volatile HAP (VoHAP). They may be used in areas where VoHAP content is not severely restricted*

#### Compatible Surfaces

##### *F3993/95/97 may be applied over:*

- Properly cleaned and sanded: steel, aluminum, galvaneal, galvanized, stainless steel, OEM finishes, fiberglass and cured finishes.
- F3950 High Solids Epoxy Primer
- F3970 Ultra High Solids Primer
- F3980 High Solids Primer
- F4921 2.1 VOC Epoxy Primer
- F4935/36/37 High Solids Epoxy Primers

**When sanding bare metal areas prior to application of F3993/95/97, use 80 grit (stainless steel) or 120-180 grit (steel and aluminum). Sand old finishes with 220-320 grit wet or dry.**

**Always use fresh sandpaper and thoroughly clean all substrates after sanding.**

**Aluminum, stainless and carbon steel must be primed immediately after cleaning and sanding.**

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## Application Data

### Selection of Substrate Cleaner:



**ONECHOICE®**  
**Commercial CFX**  
**Cleaners**

Code	Product	Purpose
CFX435LV	Low Voc Cleaner	Compliant cleaner suitable for removing dirt, grease or other contaminants before or during the painting process.
CFX436	Wax & Grease Remover	Suitable for removing dirt, grease or other contaminants before or during the painting process.
CFX437	Heavy Duty Wax & Grease Remover	Used to remove heavy milling oils and grease from bare substrates prior to the painting process.

### Mixing Ratio:



**F3993/95/97 : F3996 : F33XX**  
**3 : 1 : 1/2**

A 30-minute induction time or extended agitation after blending is recommended for optimum performance.

### Pot Life @ 70°F (21°C) / 50% RH:



6 hours

*High heat and humidity will shorten pot life.*

### Spray Viscosity:



#2 ZAHN CUP	#3 ZAHN CUP	4DIN	6DIN
40–45 seconds	12–16 seconds	22–26 seconds	9–11 seconds

### Spray Gun Set-up:



	HVLP	COMPLIANT
Fluid Tip:	1.3–1.5 mm	1.3–1.5 mm
Air Pressure:	8–10 PSI at the cap	40–50 PSI

### Number of Coats:



1–3 coats

# F3993/95/97

## Application Data continued

**Flash Off @ 70°F (21°C)**  
before force drying:



15 minutes

### Dry Times:



**Dust-Free:** 10 minutes



**Tape Time:**

70°F (21°C) 4 hours

140°F (60°C) 30 minutes



**Overcoat/Recoat:** 60 minutes – 72 hours (Max. before sanding is required)  
70°F (21°C)

*\* Force dry times are for quoted metal temperature. Additional time should be allowed in the force-drying schedule to allow metal to reach recommended temperature.*

### Film Build:

	Wet (per coat)	Dry (total)
<b>Minimum</b>	2.5 mil	1.0 mil
<b>Maximum</b>	5.0 mil	2.0 mil

### Theoretical Coverage:

560–570 sq. ft.

*Theoretical coverage in sq. ft. /US gal. Ready-to-spray (RTS), giving 1 mil. (25µm) dry film thickness (assuming 100% Transfer Efficiency).*

### Performance Comments:

A 30-minute induction time or extended agitation after blending is recommended for optimum performance.

### Physical Characteristics:

<b>VOC (Packaged):</b>	<b>F3993/95/97</b>	4.13 lbs./gal. or 493 g/L
	<b>F3996</b>	4.75 lbs./gal. or 568 g/L
	<b>F33XX</b>	7.13 lbs./gal. or 856 g/L
	<b>VOC (Ready-To-Spray):</b>	4.60 lbs./gal. or 550 g/L
<b>Total Solids By Weight (RTS):</b>		54–57%
<b>Total Solids By Volume (Packaged):</b>		<b>F3993/95/97</b>
		<b>F3993:</b> 41.95%
		<b>F3995:</b> 41.98%
		<b>F3997:</b> 41.66%
		<b>F3996:</b> 33.45%
<b>Total Solids By Volume (RTS):</b>		35–36%

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**Health and Safety:**

Safety Data Sheets (SDS) for the PPG products mentioned in this publication are available through [www.ppgcommercialcoatings.com](http://www.ppgcommercialcoatings.com) (Safety, SDS Search) or your PPG Distributor.

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**For additional information regarding this product, see the SDS and LABEL information.**

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**EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320 AND IN MEXICO 01-800-00-21-400.**

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